

**Work Order ID 68519**

Thursday, April 14, 2011 1:08:21 PM



Page 1

Item ID: D350-748-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Installation, High Fwd

Start Date: 4/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *H*Date: *11-04-14* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-748-141	F								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-748-101		CHG002						
110		0.00							
	BENDING MACHINE - CROSSTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT								
120		0.00							
	QC15- Crosstube Dimensional Check								
QC	Memo	0.00							
Quality Control									

*S wlos 125**11-8-23**DP**11-8-3**Pb***B68519 D350-748-101**

W/O: 68519

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-101 PAR #: N/A Fault Category: Landing gear cross tube. NCR: Yes ☒ No ☐ DQA: JA Date: 11-08-29  
 Resolution: acceptable Disposition: GOOD AS IS QA: N/C Closed: OK Date: 11/08/29

NCR: 68519

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/8/03	#100	tube is bent out of tol. R.C. Process	CP 11.08.03 CP510yr	tube is acceptable. Per Email Fondard Shephard to Eric Douring on Aug. 3. see Attaches	JA	8 11/08/03	CP 11.08.03 CP510yr	8 11/02/03
				(see w/o change for test)				

NOTE: Date &amp; initial all entries

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Required Date: 5/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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125

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

\*\*\*Stress relief\*\*\*

Heat treat crosstube as per QSI010 4.3

Temp: 375

Start time: 4h30

Finish time: 8h30

SAD 11-08-08

(7)

127

0.00



QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

8/16/08/05

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Start Date: 4/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Crosstubes								
Crosstubes									
Crosstubes									
	Memo	0.00							
	1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs, Set-up drill table as per QSI 010								
	2-Deburr								
	3-Engrave Part # and Batch # as per Dwg D350-748-141								
	4-Remove all marks from tube within limits of D350-748-141								
	5- Apply a light coat of LPS3 on the interior of tube Batch: <u>M10995C</u>								
140									
	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control									
	Memo	0.00							
	CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)								

SAD  
11-08-09  
JW 11-08-09  
SAD 11-08-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00



Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: 14653  
Stress relief at 375° for 5 hours  
Magnetic Particle Inspect per ASTM E1444  
Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2  
Embrittle relief at 375° for 8 hours, Chromate Treat  
Possible Supplier: Southwest United Industries  
Ensure Certificate of Conformity is attached

CL 11/08/10 ①

160

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

CL 11/08/22 ①

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulzer①PTO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11.08.22	171	GEAR LOADED TO 3500 $\frac{1}{2}$ FOR 1 MINUTE PER ATTACHED D.S. EMAIL	AS	11/08/22	1	CP 11.08.22 DSI/HR	E	
11.09.22	172	NDT tube used CZ 11/08/23 PO 14725 ACUPEN NDT 11-08-23	CZ		1	CP 11.08.22 DSI/HR	W	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	SprayPaint	0.00				<u>W</u>	<u>11</u>	<u>08</u>	<u>24</u> (1)
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Prime Outside of Tube as per Dart QSI 005 4.2								
190 	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200 	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS								

25 11-08-25W 11 08-25 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
220  Packaging Packaging	Pick Kit  Memo	0.00 0.00						11/8/25	
230  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-748-101								
	Location: _____								
	PPP Rev: <u>C</u>								
250									
	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/8/25

11/8/25

ME

11-08-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 14, 2011 1:08:27 PM

Page 1

Work Order ID: 68519

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 4/14/2011

Required Date: 5/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-07-05 JLM  
 IPP Rev:B Update qty of MS21042L5 06-09-12 KJ  
 IPP Rev:C Rev B 07-11-15 DD  
 IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD  
 IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC IPP Rev:F  
 10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-748-141TRN Manufactured No



Crosstube Turning Detail

B68821

Location

Loc Qty

Loc Code

LG046

1

64475

1

ALS4-1032-225 Purchased No



Insert

200

Each

1,159.000

1

1

11.08-25

Location

Loc Qty

Loc Code

FP-B

86

110768

86

ST282

1073

110768

1073

AN960JD10 NAS1149D0363J Purchased No



Washer

200

Each

0.0000

1

1

11.08-25

B# 111581

B# 118077

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, April 14, 2011 1:08:27 PM

Work Order ID: 68519

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 4/14/2011

Required Date: 5/5/2011

Start Qty: 1.00

Required Qty: 1.00

D2856-400 Manufactured No

200 f

231.0696 1.181 1.243158



Abraison Strip

B# 71164

Location

Loc Qty

Loc Code

ST403	216	
68076	216	
ST409	15.0696	
63735	15.0696	

D3502-1 Manufactured No

200 Each

31.0000 2 2



Support

Location

Loc Qty

Loc Code

ST063	31	
61206	12	
61843	9	
64004	10	

MS21920-20 Purchased No

200 Each

72.0000 2 2



Clamp (per MIL-DTL-8783C)

B# 118236

Location

Loc Qty

Loc Code

LG050	72	
116799	22	
117279	50	

MS27039-1-10 Purchased No

200 Each

80.0000 1 1



Screw

B# 117441

Location

Loc Qty

Loc Code

ST291	80	
115935	80	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Crosstube Installation, High Fwd

Start Date: 4/14/2011

Required Date: 5/5/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-41A

Purchased

No

220

Each

198.0000

8

8



Bolt

Location

Loc Qty

Loc Code

ST360

198

115108

98

115705

50

116191

50

AN4-6A

Purchased

No

220

Each

1,071.000

16

16



Bolt

Location

Loc Qty

Loc Code

ST356

1071

115936

200

116191

71

116400

400

116924

400

AN5-32A

Purchased

No

220

Each

137.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST340

137

115108

27

115589

60

117161

50

AN960JD416

NAS1149D0463J

Purchased

No

220

Each

0.0000

32

32



Washer

AN960JD516

NAS1149D0563J

Purchased

No

220

Each

0.0000

8

8



Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Crosstube Installation, High Fwd

Start Date: 4/14/2011

Required Date: 5/5/2011

Start Qty: 1.00

Required Qty: 1.00

D3500-1

Manufactured No

220

Each

35.0000

4



Saddle

Location

Loc Qty

Loc Code

ST424/25

20

62207

20

ST425

15

61838

15

D3501-1

Manufactured No

220

Each

67.0000

16



Bushing

Location

Loc Qty

Loc Code

ST063

67

61984

67

MS21042L4

Purchased No

220

Each

2,670.000

24



Nut

Location

Loc Qty

Loc Code

ST300

2670

116188

670

116823

2000

MS21042L5

Purchased No

220

Each

765.0000

4



Nut

Location

Loc Qty

Loc Code

ST300

765

115594

5

116105

500

116548

260

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

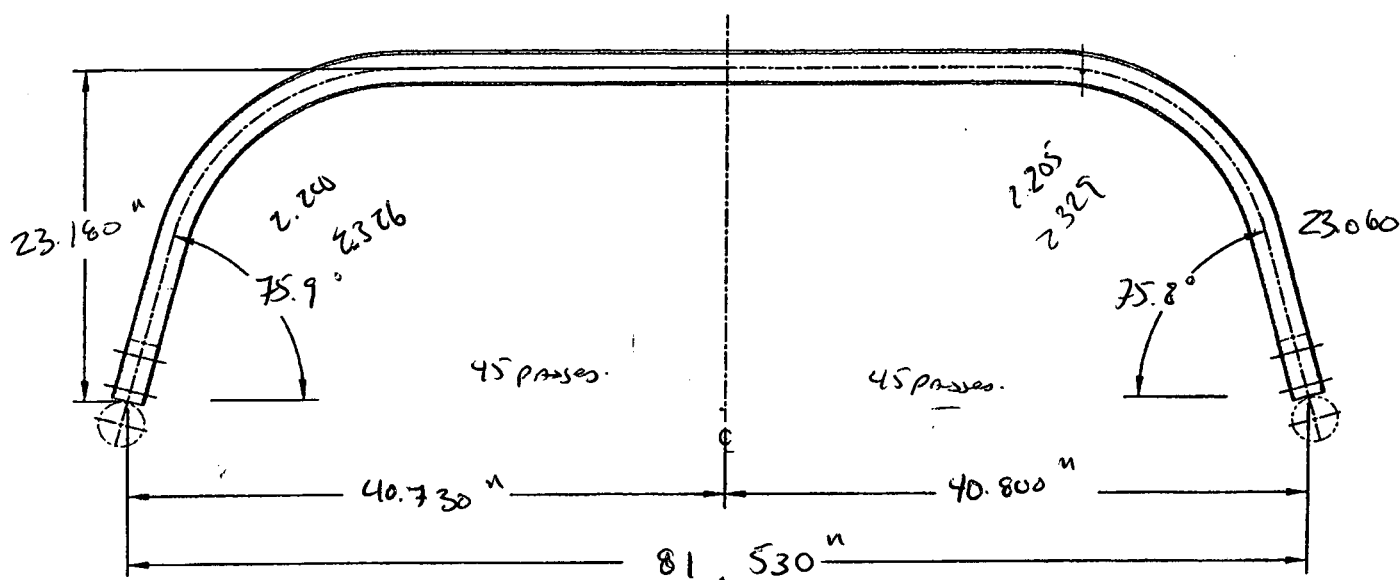
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	Q8829
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141		Rev: E	Page 1 of 1

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments	
twist 2 @ .241	
side A ~ 2.7% crushing @ 45 passes	
side B ~ 2.7% crushing @ 45 passes	

QC15 Inspection	S
Date	11/08/03

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

# GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115  
FINISHED LENGTH = 110.270±0.06
- FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF  
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 30.45 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.  
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 11109414

RELEASED  
2011-01-18

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.23		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D350-748-141  
REV. F  
SHEET 1 OF 4  
TITLE CROSSTUBE (AS 350/355 HI FWD)  
SCALE NTS

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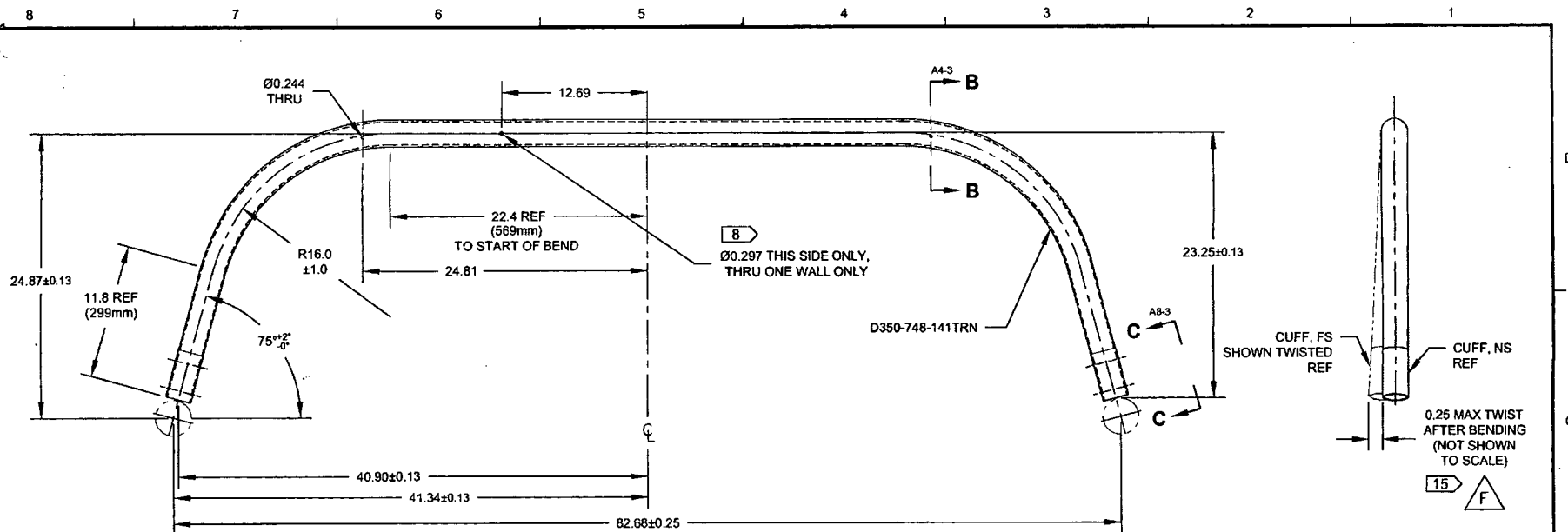
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

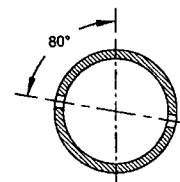
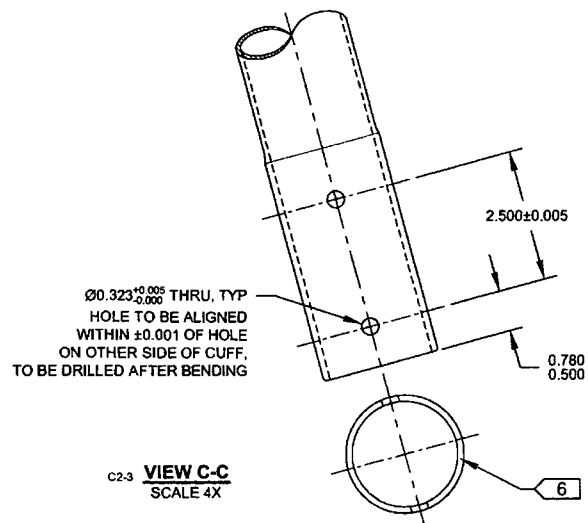
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D350-748-141**  
**BENDING AND DRILLING DETAIL** 10

*w/068519*



**SECTION B-B** D3-3  
SCALE 4X

**RELEASED**  
R 2011-01-18  
*MD*

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. F
MFG. APPR.	2	D350-748-141	SHEET 3 OF 4
APPROVED	17	TITLE	SCALE
DE APPR.	17	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

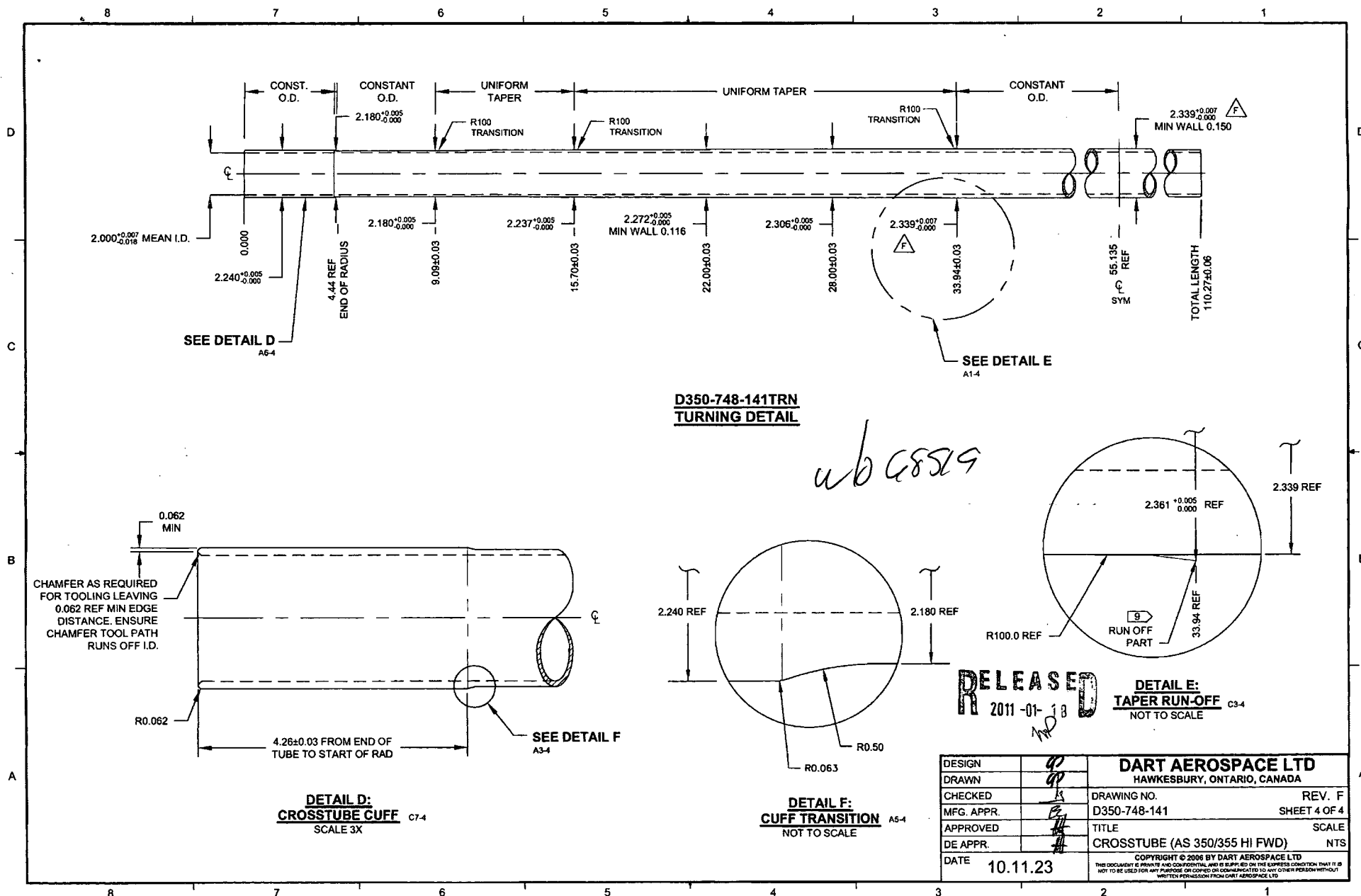
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Eric Downing

---

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** August 3, 2011 4:36 PM  
**To:** 'Eric Downing'  
**Cc:** 'Bill Beckett'; 'Mike Petsche'; 'L Lacelle'; 'Susanne Sheldon (Susanne Sheldon)'; 'Chris Provencal'  
**Subject:** RE: 350 cross tubes out of tol.

Eric,

Not sure what to tell you ... I think this is a scrap tube ... It is already 0.33" narrower than nominal ... If we trim it to make it level, it will be close to 0.50" narrower than nominal ... Compounded with the fact that it is twisted by almost 0.50" ... With everything that is wrong with this tube, I don't think Chris would accept it either ... It's going to be tough for a customer to get everything to line up and he will have to pre-stress the gear quite a bit to get it together. Please scrap the tube, or set it aside for development testing.

Thanks,  
David

---

**From:** Eric Downing [mailto:edowning@dartaero.com]  
**Sent:** August-03-11 2:10 PM  
**To:** 'David Shepherd'  
**Cc:** 'Bill Beckett'; 'Mike Petsche'; 'L Lacelle'; 'Susanne Sheldon (Susanne Sheldon)'  
**Subject:** RE: 350 cross tubes out of tol.

David

Sorry about that David I didn't see it was missing a batch #. The # is 72502. I re attached the dim sheet with the correct Batch # on it.

For tube B68520 could we cut it to the correct height and span and from talking to Dan Paquette he has told me that Chris has approved that high of a twist before. I'll look tomorrow to make sure we have in the past. But I know that we are up against the wall( as Bill would say) to try to get as many tubes as possible sent out for Cad plating so if it could be saved it would be much appreciated. But if it can't it can't then it should be scrapped.

Downing

---

**From:** David Shepherd [mailto:dshepherd@dartaero.com]  
**Sent:** August 3, 2011 3:58 PM  
**To:** 'Eric Downing'  
**Cc:** 'Bill Beckett'; Mike Petsche; 'L Lacelle'; 'Susanne Sheldon (Susanne Sheldon)'  
**Subject:** FW: 350 cross tubes out of tol.

Eric,

B68519 is acceptable  
B????? is acceptable (please add a B/N to inspection sheet)

B68520 is badly twisted and has height/spread difference from side-to-side of 0.25" so I think it should be scrapped.

David

**From:** Eric Downing [mailto:edowning@dartaero.com]

**Sent:** August-03-11 1:37 PM

**To:** 'David Shepherd'; 'Mike Petsche'

**Cc:** Bill Beckett; Linda Lacelle; Susanne Sheldon

**Subject:** 350 cross tubes out of tol.

Hey David

I have Qty 3 cross tubes that are out of tolerance and need to be approved by you. I have scanned the dim sheets and attached them to the email. I need an answer ASAP to be able to put them in the oven to get the stress relief done.

Thanks

**Eric Downing**

**QC COORDINATOR**

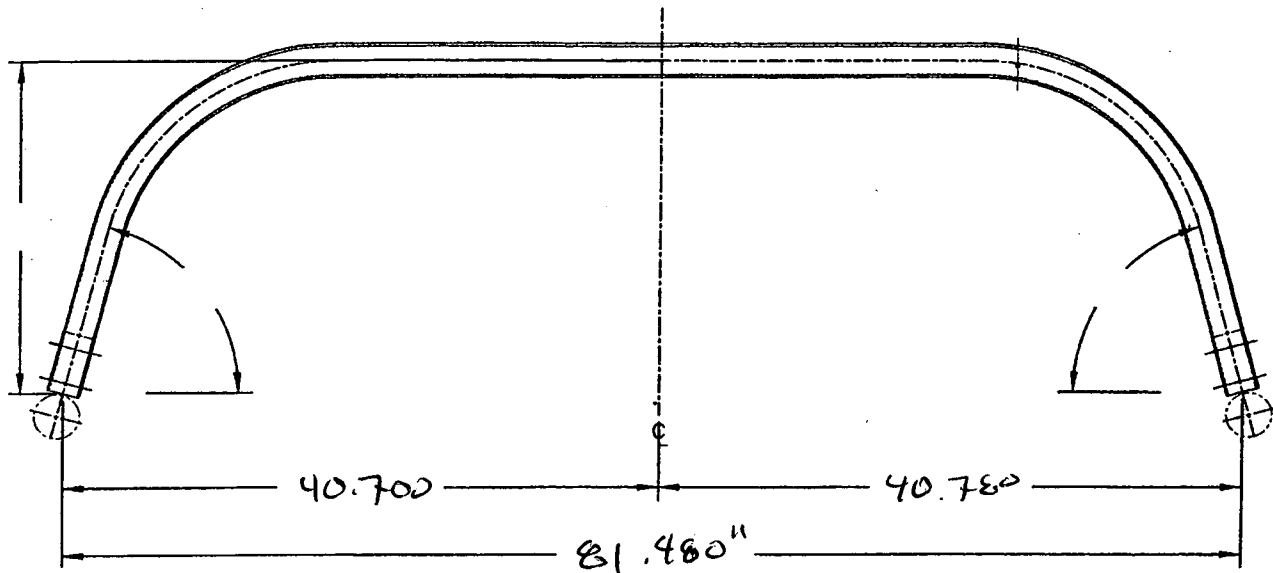
**DART AEROSPACE**

**EDOWNING@DARTAERO.COM**



DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
Height = 0.241"

QC15 Inspection	
Date	11/02/15

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

5

100

11000 = 1000

11.1

# Packing Slip



CADORATH  
COATING

## Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

56257

**Sold To:**

Dart Aerospace Ltd.  
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

**ShipTo:**

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

**Customer Order #:**

14653

**Date Received:**

Aug-15-2011

**Terms:**

NET 30 DAYS

**G.S.T. #:**

10071 6547 RT0001

**Ship Via:**

**Ship Date:**

Aug-19-2011

**Item # Qty P/N & Description**

1	1 EA	SKID	S/N B68519	✓
		P/N d350-748-101	W/O 106856	
2	1 EA	SKID	S/N B72502	✓
		P/N d350-748-101	W/O 106857	
3	1 EA	SKID	S/N B61773	—
		P/N D350-748-201	W/O 106858	
4	1 EA	SKID	S/N B61774	—
		P/N D350-748-201	W/O 106859	

CL 11/08/22

## Chris Provencal

---

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** Tuesday, April 27, 2010 3:40 PM  
**To:** 'Mike Petsche'  
**Cc:** 'Bill Beckett'; 'L Lacelle'; 'Chris Provencal'; 'Dan Stow'; ssheldon@dartaero.com  
**Subject:** 350 crosstubes

Mike,

I discussed the 350 crosstube load testing with Bill a little while ago and this plan makes sense to him.

So, my recommendation to clear these crosstubes is to load the fwd crosstubes to 3500 lb and the aft crosstubes to 3000 lb in the deflection test rig and document on the work orders that this test has been completed. Hold max load for 1 minute. Per TP-D350-748-2, these loads represent the maximum load on these crosstubes at gross weight and are below the yield point of the material. I would like to request that Chris Provencal witness these tests and sign off the work orders based on his experience with Dart landing gears. My feeling is that if there is a problem with the parts, it will manifest itself during this load test. I, for one, would feel a lot more confident in testing each crosstube in this manner than relying totally on what Exova has to say. I think it would be very difficult to reach a conclusion on the whole batch on the basis of cracks in two parts from the batch.

I believe that we can accomplish this before next Friday, which also gives us time to hear what Exova has to say in case it has an impact on our decision. So far, what I have seen from Exova shows me that there are fluctuations in the heat treating but the tubes are heat treated to our specification.

For this reason, I believe we should tell DHS that it looks like we will be able to start shipping 350 crosstubes by May 7th pending a successful Engineering test of the material.

David.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ACUREN

## LIQUID PENETRANT TEST REPORT

P- 05628

CLIENT

ATTENTION

ADDRESS

PROJECT

ITEM(S) EXAMINED

DATE

ACUREN JOB NO.

PO/NO.

WORK LOCATION

ACCEPTANCE STD.

PAGE

AM

PM

DART AEROSPACE  
LYNDA / CHAUNCEY / IAN / MATTAUG 23 / 2011  
18811-02167

HAWKEBURY, ON

AS ADDRESS

PT WET FLUORESCENT ON 4 CROSS TUBES

ASTM A1754/2508 REV./DATE 2005

- SEE BELOW

OB DESCRIPTION

PROCEDURE NO. LT-002

REV./DATE 2008

TECHNIQUE NO. LT-002

REV./DATE 2008

ART NO.

COPE

V STEEL / CADMIUM PLATING MATERIAL ~~ALUMINUM~~ THICKNESS N/A  
PERFORMED A WET FLUORESCENT L.P. INSPECTION ON 100% OF THE EXTERNAL SURFACE ON ITEMS MENTIONED BELOW

## TEST DETAILS

METHOD

☒ FLUORESCENT☐ VISIBLE☒ WATER WASH☐ SOLVENT REMOVABLE☐ POST EMULSIFIED

AMILY BRAND

MAGNA FLUX

BLACK LIGHT S/N 13798

☐ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup>☒ AMBIENT < 2 fc

ENETRANT

ZL-67

MINIMUM DWELL TIME

10

MIN.

LIGHTING EQUIP.

☐ FLASHLIGHT☐ TROUBLELIGHT☐ OUTPUT > 100 fc @ SURFACE

ENETRANT REMOVER

H2O

MINIMUM DRY TIME

&gt;10

MIN.

OTHER

DEVELOPER

SKD-52

MINIMUM DWELL TIME

10

MIN.

LIGHT METER S/N

CAL DUE DATE AUG 2012

DEVELOPER TYPE

☒ NON AQUEOUS☐ AQUEOUS☐ DRY

## TEST SURFACE

SURFACE CONDITION

☐ AS GROUND☐ AS WELDED☐ MACHINED☐ SHOT BLASTED☒ CLEAN BARE METAL

SURFACE TEMPERATURE

☐ < -4°C / 20°F☐ -4°C / 20°F TO 10°C / 50°F☒ 10°C / 50°F TO 52°C / 125°F☐ > 52°C / 125°F

## RESULTS-

☐ METRIC ☐ IMPERIAL

1	CROSSTUBE	W.O. ID	61773
2	"	W.O. ID	61774
3	"	W.O. ID	68519
4	"	W.O. ID	72500

ITEM ID	D 350-748-201	AFT
ITEM ID	D 350-748-201	AFT
ITEM ID	D 350-748-101	FWD
ITEM ID	D 350-748-101	FWD

NO RELEVANT INDICATION WAS DETECTED AS PER APPLICABLE STANDARDS

NOTE: MTC: STEEL + CADMIUM PLATING

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE

Ian Titley

PRINT

[Signature]

SIGNATURE

DTR # E44712

TECHNICIAN (SIGNATURE):

[Signature]

1<sup>ST</sup> TECHNICIAN

NAME (PRINT):

CGSB LEVEL

SNT LEVEL

CGSB REG. NO.

2049

CGSB LEVEL

SNT LEVEL

CGSB REG. NO.

REPORT

REVIEWED BY:

NAME

INITIALS

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

PT Sept 2005

## REFERENCE ONLY

## 32.7 WEIGHT AND BALANCE

The following weight and balance information is for Dart crosstube installations only. This data should be similar to the existing installation. Differences from the parts removed are the responsibility of the installer.

DART CROSSTUBE	FWD/ AFT	WEIGHT	STA	MOMENT
D350-748-101	Fwd	35.2 lb (16.0 kg)	106.3 in (2.70 m)	3742 lb-in (43.2 kg-m)
D350-748-201	Aft	34.7 lb (15.7 kg)	162.4 in (4.12 m)	5635 lb-in (64.7 kg-m)

## 32.8 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

\* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE